

Work Order ID 128800

Tuesday, January 27, 2015 7:48:18 AM

128800

Page 1

Item ID: D350-561-045

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Dual Mirror Accessory

Start Date: 1/16/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/26/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MLS Date: 15-01-28 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
IIN-D350-561	E	<i>label white 68-6 9</i>							

100	Document Control	0.00	<i>DAS 6 9-89</i>						
100	DOCUMENT CONTROL		<i>SEP 23 2015</i>						
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-561-045	CHG003							

105	Pick Kit	0.00	<i>DAS 26 27 9-89</i>						
105			<i>SEP 16 2015</i>						
Packaging	Memo	0.00	<i>IX</i>						
Packaging									

110	QC4- 100% Inspect kits for completeness	0.00	<i>DAS 6 9-89</i>						
110			<i>SEP 23 2015</i>						
QC	Memo	0.00							
Quality Control									

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 128800

Tuesday, January 27, 2015 7:48:18 AM

128800

Page 2

Item ID: D350-561-045

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Dual Mirror Accessory

Start Date: 1/16/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/26/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
120									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-561-045								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

20150923

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, January 27, 2015 7:48:18 AM

Page 1

Work Order ID: 128800

128800

Parent Item: D350-561-045

D350-561-045

Parent Item Name: Dual Mirror Accessory

Start Date: 1/16/15

Required Date: 1/26/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP D05.09.15 Step 3 pick list revised per D350-561 Rev.
 CKJ/JLM IPP Rev:E
 add pick kit DD 10.04.19 verified by:EC IPP Rev:F 10.09.14 per
 IIN revD DD verf:EC IPP REV:G 12.05.30 PER ECN 12-
 596 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN3-5A		Purchased	No			105	Each	240.0000	2				
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AN3-5A
Bolt

** 2 m 131420 DAS DAS 26 27 9-89-89

Location	Loc Qty	Loc Code
----------	---------	----------

CA	151	
m129682	151	
FP001	49	
m130325	49	
GA	40	
m129507	40	

D2011-101		Manufactured	No			105	Each	54.0000	1				
-----------	--	--------------	----	--	--	-----	------	---------	---	--	--	--	--

D2011-101
Mirror 6"

** 1 DAS DAS 26 27 9-89-89

Location	Loc Qty	Loc Code
----------	---------	----------

FG	2	
106348	2	
ST384	52	
113569	6	
122000	46	

D2012-113		Manufactured	No			105	Each	17.0000	2				
-----------	--	--------------	----	--	--	-----	------	---------	---	--	--	--	--

D2012-113
Clamp

** 2 DAS DAS 26 27 9-89-89

Location	Loc Qty	Loc Code
----------	---------	----------

ST002	17	
113593	17	

SEP 16 2015

2x

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

Work Order ID: 128800

128800

Parent Item: D350-561-045

D350-561-045

Parent Item Name: Dual Mirror Accessory

Start Date: 1/16/15

Required Date: 1/26/15

Start Qty: 1.00

Required Qty: 1.00

D3635-3

Manufactured No

105

Each

10.0000

2 2

D3635-3

Gasket

DAS
6
9-89

Location

Loc Qty

Loc Code

ST052

10

122614

10

NAS1149D0363J

Purchased

No

105

Each

1,517.000

4

NAS1149D0363J

Washer

**

2x
④
m133031

DAS
26
9-89
27
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

CA

673

m130799

673

FP001

144

m126319

144

GA

681

m128429

681

ST269

19

122378

7

m126319

12

DAS
6
9-89

SEP 16 2015

DQA: _____ Date: _____

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 3

Work Order ID: 128800

128800

Parent Item: D350-561-045

D350-561-045

Parent Item Name: Dual Mirror Accessory

Start Date: 1/16/15

Required Date: 1/26/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

105

Each

4,834.000

NAS1149D0463J
WASHER

**

m132035

DAS
26
9-89

DAS
27
9-89

DAS
6
9-89

MS21042L3

Purchased

No

105

Each

2,639.000

MS21042L3
Nut

**

m133134

DAS
26
9-89

DAS
27
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

CA	397	
M129682	397	
GA	408	
M129390	408	
ST260a	1153	
M129390	1153	
ST269	2876	
M129390	12	
M130799	2864	

Location

Loc Qty

Loc Code

FP001	420	
M130922	420	
ST305	2216	
M130799	11	
M131264	1205	
M131317	1000	
ST307	3	
123900	3	

SEP 16 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Item ID: D350-561-045

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Dual Mirror Accessory

Start Date: 1/16/15 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/26/15 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: ML5 Date: 15-01-28 Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-561	E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-561-045				CHG003				
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									
110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.00							
Quality Control									

ML5

AUG 25 2015

5. PARTS LIST

Qty -041	Qty -043	Qty -045	Qty -141	Qty -143	Qty -241	Qty -243	Part Number	Description
X	1						D350-561-041	SINGLE MIRROR INSTALLATION, RH
	X						D350-561-043	DUAL MIRROR INSTALLATION, RH
	1	X		1		1	D350-561-045	MIRROR KIT
			X	1			D350-561-141	SINGLE MIRROR INSTALLATION, RH
				X			D350-561-143	DUAL MIRROR INSTALLATION, RH
					X	1	D350-561-241	SINGLE MIRROR INSTALLATION, LH
						X	D350-561-243	DUAL MIRROR INSTALLATION, LH
1					1		D2011-101	Mirror
1							D2012-101	Arm
1							D2012-103	Arm
1							D2012-105	Arm
					1		D2012-106	Arm
2					1		D2012-107	Clevis
1							D2012-109	Bracket
1					1		D2012-111	Bracket
4							D2012-113	Clamp
1					1		D2012-115	Bracket
4					2		D2022-101	Spacer
4							D2856-100-325	Abrasion Strip
1*		1*	1*		1*		D3014-1	Locknut
					1		D3629-1	Bracket
					1		D3635-1	Gasket
							D3635-3	Gasket
							D3646-1	Arm
					1		D3646-2	Arm
							D3646-3	Arm
					1		D3646-4	Arm
					2		D4070-041	Clamp
2							AN3-4A	Bolt
2					6		AN3-5A	Bolt
1					1		AN3-6A	Bolt
2					1		AN4-10A	Bolt
3					3		AN4-5A	Bolt
14					8		AN960JD10	Washer
9					8		AN960JD216	Washer
1*					1*		AN960JD416L	Washer
5					4		MS21042-3	Nut (or MS21042-3)
5					4		MS21042-4	Nut (or MS21042-4)

*INCLUDED AS PART OF D2011-101 MIRROR